Work Order ID 112014

Tuesday, January 28, 2014 1:38:22 PM

112014

Item ID: D4869-1 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID:

Item Name: End Fitting, Eye **Stop** *NS2*

Start Date: 1/28/2014 **Start Qty:** 7.00 *7*

Required Date: 2/14/2014 **Req'd Qty:** 7.00 *7*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** MF. **Date:** 14-1-28 **Tooling:** _____ **Date:** _____ **Run Start** *NR1*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D4869	**Revision Nbr** Rev A								
100	DOOSAN LATHE	0.00							
100									
Outsource5	**Memo**	0.00							
Outsource process - Machining	ISSUE P/O: 22838 POSSIBLE SUPPLIER:ATG C OF C IS REQUIRED								
110	QC6- Inspect dimensions to drawing	0.00							
110									
QC	**Memo**	0.00							
Quality Control									
150	PURCHASING	0.00							
150									
Purchasing	**Memo**	0.00							
Purchasing	Issue P/O: _____ LPI Per ASTM 1417 LEVEL 2 Certificate of conformaty is required								

DAS 27 9-89 14/3/14

DAS 27 9-89

7

14/1/30

SP 14-3-14

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Item ID: D4869-1 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: End Fitting, Eye
Start Date: 1/28/2014 **Start Qty:** 7.00 *7* **Cust Item ID:**
Required Date: 2/14/2014 **Req'd Qty:** 7.00 *7* **Customer:**
Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** *NR1*
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Receive & Inspect for Damage & Mat'l Certs	0.00							
160						7X		14-3-12.SP	
Packaging	**Memo**	0.00							
Packaging	Ensure certificate of conformity is attached								
	5T137					14/3/13		DAS 32 9-89	
190	QC21- Final Inspection - Work Order Release	0.00							
190						MLS 14-03-13			
QC	**Memo**	0.00							
Quality Control									

MLS 14-03-13

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Picklist Print

Tuesday, January 28, 2014 1:38:20 PM

Work Order ID: 112014

Parent Item: D4869-1

Parent Item Name: End Fitting, Eye

Start Date: 1/28/2014 **Required Date:** 2/14/2014

Start Qty: 7.00 **Required Qty:** 7.00

Comments: IPP REV:A NEW ISSUE 14-01-16 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4869-1P End Fitting, Eye		Purchased	No				Each	0.0000		7	7x	14-3-12. SP.	
M174PH-H900R1.000 17-4SS H900 ROUND BAR 1.00		Purchased	No				f	104.0000		2		CP 13/01/30	

Location	Loc Qty	Loc Code	
MAT031	104		
m126952	44		2
m127334	60		

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

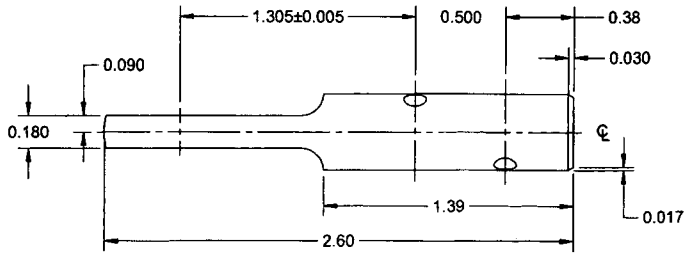
FAULT CATEGORY

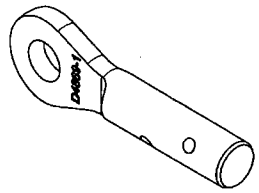
Landing Gear

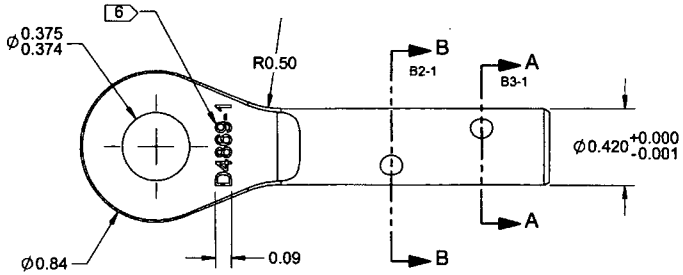
☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

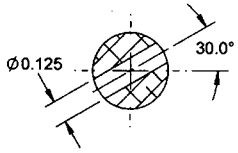
General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
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☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

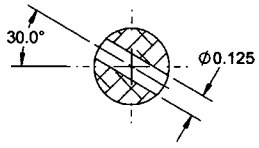








SECTION A-A C5-1



SECTION B-B C6-1

#112014
14-1-28

D4869-1 END FITTING, EYE

NOTES:
1) MATERIAL: 17-4 PH/S17400/TYPE 630 SS ROUND BAR, H900 CONDITION
PER AMS 5643/ASTM A564
DART SPEC M17-4-R
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.3.
ENGRAVE P/N USING 0.09 HIGH LETTERS TO A MAX. DEPTH OF 0.010
7) WEIGHT: 0.08 lbs
8) LIQUID PENETRANT INSPECT PER QSI 038 6.1.1 (ASTM E1417 LEVEL 2)

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	RF	13.09.16

APPROVED

DESIGN	RF	DART AEROSPACE LTD
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	HS	DRAWING NO. D4869 REV. A
MFG. APPR.	JLM	SHEET 1 OF 2
APPROVED	HS	TITLE END FITTING
DE APPR.	DS	SCALE NTS
DATE	13.12.16	

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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

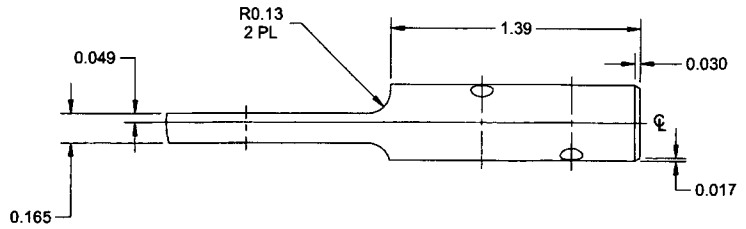
FAULT CATEGORY

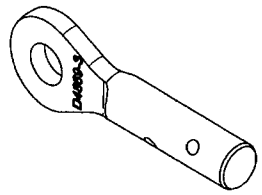
Landing Gear

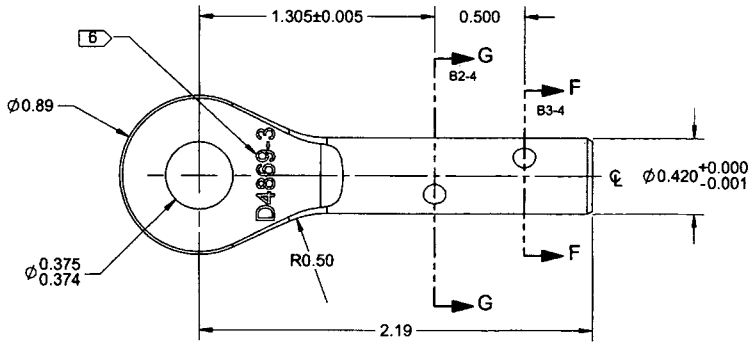
☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

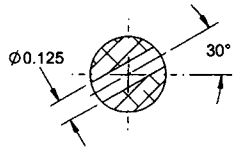
General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
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☐ Grain
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☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

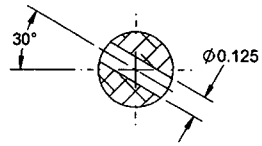








SECTION F-F B5-4



SECTION G-G B6-4

112014

D4869-3 END FITTING, EYE

RELEASED

NOTES:
1) MATERIAL: 17-4 PH/S17400/TYPE 630 SS ROUND BAR, H900 CONDITION
PER AMS 5643/ASTM A564
DART SPEC M17-4-R
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.3.
ENGRAVE P/N USING 0.10 HIGH LETTERS TO A MAX. DEPTH OF 0.010
7) WEIGHT: 0.08 lbs
8) LIQUID PENETRANT INSPECT PER QSI 038 6.1.1 (ASTM E1417 LEVEL 2)

APPROVED

DESIGN	RF	**DART AEROSPACE LTD**
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	HS	DRAWING NO. D4869 — REV. A
MFG. APPR.	JLM	SHEET 2 OF 2
APPROVED	HS	TITLE: END FITTING — SCALE: NTS
DE APPR.	DS	
DATE	13.12.16	

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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
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☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
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☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
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☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE STREET
ROCKLAND, ON K4K 1T2
Canada

Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 907542 Date: 12-Mar-14

To

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613 632-9577 Fax: 613 632-1053

Ship To

Michael Gregoire
DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613 632-9577 Fax: 613 632-1053

Terms	Ship Via

Quantity	Description
	PLEASE REFERENCE THE PACK LIST NUMBER ON ALL CORRESPONDENCE TO THIS SHIPMENT. IF YOU HAVE ANY QUESTIONS, PLEASE CALL AT (613) 446-4544.
6 ea	Part: D4805-3P Rev: A END FITTING Job: 15716 PO: PO22838 Line: 13
4 ea	Part: D4805-5P Rev: A END FITTING Job: 15717 PO: PO22838 Line: 14
3 ea	Part: D4806-1P Rev: A CLEVIS Job: 15709 PO: PO22838 Line: 6
6 ea	Part: D4808-1P Rev: A ROD END Job: 15710 PO: PO22838 Line: 7
7 ea	Part: D4869-1P Rev: A END FITTING, EYE Job: 15711 PO: PO22838 Line: 8
3 ea	Part: D4869-3P Rev: A END FITTING, EYE Job: 15712 PO: PO22838 Line: 9
	DATE : 12/03/2014 CERTIFIED SIGNATURE: RECEIVER SIGNATURE : SP 14-3-12. CERTIFICATE OF CONFORMANCE A.T.G. INDUSTRIES INC. CERTIFIES THAT ALL ITEMS IN THIS SHIPMENT ARE IN CONFORMANCE WITH THE REQUIREMENTS, SPECIFICATIONS, AND DRAWINGS REFERENCED IN THE ABOVE PURCHASE ORDER.

First Article Inspection Report

ATG INDUSTRIES INC.

731 Industrielle St
Rockland, Ontario K4K 1T2
Ph: 613 446-4544

Customer:	Dart Aerospace	Date:	March 12th, 2014	457
Part Number:	D4869-1P	Revision:	A	
PO Number:	PO22838	Qty:	7	FAI No.

Item	Dimension	Measurement Inspected by: Rene Tougas, Q.C.	Remarks
1	.090	.091	
2	1.305±.005	1.306	
3	.500	.500	
4	.38	.381	
5	.030	.025	
6	.017	.014	
7	1.39	1.386	
8	2.60	2.599	
9	.180	.183	
10	Ø.420+.000/-.001	Ø.4199	
11	.09	.095	
12	Ø.84	Ø.835	
13	Ø.375/.374	Ø.3750	
14	Note 6	X	
15	R.50	R.500	
16	30º	30º	Section A-A
17	Ø.125	Ø.125	
18	Ø.125	Ø.125	Section B-B
19	30º	30º	
20	Material:	17-4SS H900 1" RD BAR	Supplied by Customer
21	Treatment:	Liquid Penetrant	PO#20140098

COPY

skyservice Work Order Traveler

Sky Service F.B.O. Inc.

DOT APP 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO20177	**Customer:** Cash Sale	**Dept:** NDT YUL	**Reference:** 20140098
Descr:	**PN:**	**S/N:**	**Qty:** 1
Make:	**Model:**	**Reg:**	**A/C S/N:**
TSN: 0	**CSN:** 0	**TSO:** 0	

Task: UNSCHEDULED | **Sequence:** 1

Work Required:

CARRY OUT NDT ON 33 PARTS AS PER PO: 20140098

Action Taken:	Date:	Initial/Stamp:
LPI C/O ASTM E-1417M-13 NO CRACK FOUND PEN.(ZL-37 , B#10A070), CLEAN(SKC-S,B#09F21K),DEV.(SKD-S2,B#09L04K) EMU.(ZR-10B,B#10A074).	MAR 10 2014	DOT - APP 20 53-89

Description	*Location*	*P/N*	*Qty*	*Batch*	*S/N Off*	*S/N On*

COPY

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:	**ACA/SCA Stamp**	Date:
Name: RAFIK MELIKIAN	DOT - APP 20 53-89	MAR 10 2014

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO22838

Purchase Order Date 1/30/2014
PO Print Date 1/30/2014

Order From : VC-ATG001

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name		**Buyer**	Michael Gregoire
Vendor Phone	613-446-4544	**Customer POID**	
		Customer Tax #	10127-2607
Ship To Contact		**Terms**	Net 30
Ship To Phone		**Currency**	CAD
Ship Via:	VENDOR'S TRUCK	**FOB**	FCA – (Free Carrier)
Ship Acct:			

Line Total: **$384.00**

6	D4806-1P	Clevis	3/7/2014 Yes 3/7/2014	3.00 Each		$235.00	$705.00

Manufacture as per drawing D4806 rev.A
Made from 17-4SS H900 Round Bar 1.000"
B112026

Line Total: **$705.00**

7	D4808-1P	Rod End	3/7/2014 Yes 3/7/2014	6.00 Each		$71.75	$430.50

Manufacture as per drawing D4808 rev.A
Made from 17-4SS H900 Round Bar 1.000"
B112028

Line Total: **$430.50**

8	D4869-1P	End Fitting, Eye	3/7/2014 Yes 3/7/2014	7.00 Each		$71.75	$502.25

Manufacture as per drawing D4869rev.A
Made from 17-4SS H900 Round Bar 1.000"
B112014

SP 14-3-12.

PO Instructions: Procurement Quality Clauses
A004 FAA-PMA /TSO
A005 RIGHT OF ENTRY
A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION SENT TO DART AEROSPACE)
A016 PERSONNEL QUALIFICATION
A024 PROCESS CERTIFICATIONS
A025 CERTIFICATE OF CONFORMANCE
A040 NOTIFICATION OF QUALITY ESCAPE
A041 QUALITY MANAGEMENT SYSTEM